

Work Order ID 78328

78328

Page 1

January-05-12 10:39:17 AM

Item ID: D4034-041 Accept ***N900040100*** Setup Start ***NS1***
 Revision ID: Stop ***NS2***
 Item Name: Aft Upper Rib Assembly
 Start Date: 05/01/2012 Start Qty: 3.00 ***3*** Cust Item ID:
 Required Date: 11/01/2012 Req'd Qty: 3.00 ***3*** Customer:
 Reference:

Approvals: Process Plan: M.L.J Date: 12/01/05 Tooling: _____ Date: _____ Run Start ***NR1***
 QC: _____ Date: _____ SPC (Y/N): _____ Date: _____ Stop ***NR2***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
Draw Nbr	Revision Nbr								
D4034	B								

100 Weld per dwg A/R S.S. rod Batch: M114509 0.00
100
 Large Fab Memo 0.00
 Large Fab 1- Assemble ribs to hoop and weld as per dwg DT9564
 2- Weld bushing in rib and grind weld flush as per dwg

(X5) MAL 12/05/10
 (5x) LH 12.05.10

110 QC9- Inspect visual per QSI004- Fusion Welds 0.00
110
 QC Memo 0.00
 Quality Control

5x Ø [Signature] 12.05.10

120 QC5- Inspect part completeness to step on W/O 0.00
120
 QC Memo 0.00
 Quality Control

(5) [Signature] 12.05.10

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
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NOTE: Date & initial all entries

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Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____ Run Start ***NR1***
 QC: _____ Date: _____ SPC (Y/N): _____ Date: _____ Stop ***NR2***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
130	Identify as per dwg & Stock Location: <u>WA</u>	0.00							
130									
Packaging	Memo	0.00							
Packaging									
140	QC21- Final Inspection - Work Order Release	0.00							
140									
QC	Memo	0.00							
Quality Control									

5X ϕ P612-05-16
 12/5/17
 12-05-16

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

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NOTE: Date & initial all entries

Picklist Print

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Page 1
2

Work Order ID: 78328

Parent Item: D4034-041

Parent Item Name: Aft Upper Rib Assembly

78328

D4034-041

Start Date: 05/01/2012

Required Date: 11/01/2012

Start Qty: 3.00

Required Qty: 3.00

Comments: IPP RevA: new issue DD 09.11.23 verified by:EC IPP Rev:B as
per dwg revA 10.03.15 verified by:EC IPP Rev:C 11.01.19 AS PER
DWG REV.B DD VERF:EC

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
D4034-1 *D4034-1* Rib		Manufactured	No			100	Each	3.0000	1	3			
									**	Pl 12-05-09 381467 → (5)			
						<u>Location</u>	<u>Loc Qty</u>	<u>Loc Code</u>					
						WA006	3						
						74780	3						
D4034-3 *D4034-3* Rib		Manufactured	No			100	Each	1.0000	1	3			
									**	Pl 12-05-09 382982 → (5)			
						<u>Location</u>	<u>Loc Qty</u>	<u>Loc Code</u>					
						WA006	1						
						74918	1						
D4021-7 *D4021-7* Hoop		Manufactured	No			100	Each	2.0000	1	3			
									**	Pl 12-05-09 382976 → (5)			
						<u>Location</u>	<u>Loc Qty</u>	<u>Loc Code</u>					
						WA005	2						
						74807	2						

Pl 12.05.09
381467 → (5)

Pl 12.05.09
382982 → (5)

Pl 12.05.09
382976 → (5)

W/O:		WORK ORDER CHANGES					
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Picklist Print

January-05-12 10:39:22 AM

Page 2

Work Order ID: 78328

Parent Item: D4034-041

Parent Item Name: Aft Upper Rib Assembly

78328

D4034-041

Start Date: 05/01/2012

Required Date: 11/01/2012

Start Qty: 3.00

Required Qty: 3.00

D4021-9

Manufactured No

100

Each

94.0000

4

12

D4021-9

Bushing

**

pl 12 05.09

Location

Loc Qty

Loc Code

WA005

94

66437

2

70333

4

72482

24

74966

64

B82 348 → (20)

January-05-12 10:39:22 AM

Shop Packet Print

Page 2

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

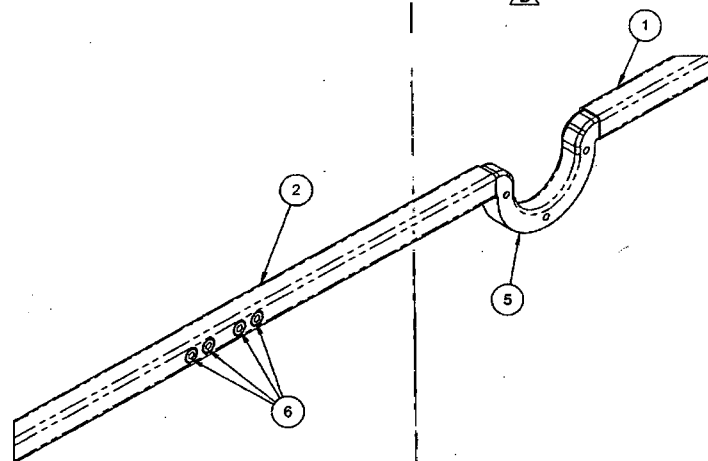
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Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

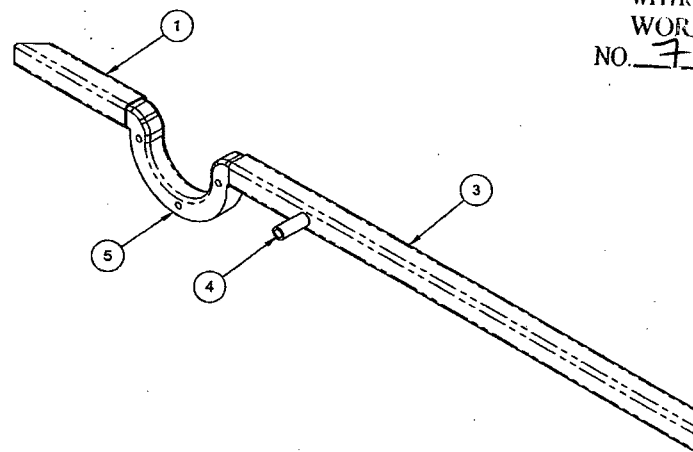
NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
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NOTE: Date & initial all entries

ITEM	QTY -041	QTY -043	P/N	DESCRIPTION
	X		D4034-041	AFT UPPER RIB ASSY
		X	D4034-043	FWD UPPER RIB ASSY
1	1	1	D4034-1	RIB
2	1		D4034-3	RIB
3		1	D4034-5	RIB
4		1	D2327-3	SPACER BUSHING
5	1	1	D4021-7	HOOP
6	4		D4021-9	BUSHING



D4034-041 AFT UPPER RIB ASSY



D4034-043 FWD UPPER RIB ASSY

SHOP COPY
RETURN TO
ENGINEERING
UNCONTROLLED COPY
SUBJECT TO AMENDMENT
WITHOUT NOTICE
WORK ORDER NO. 78328
M.L.J.
12/01/05

RELEASED
2011-01-18
AM

B	ADDITIONAL HOLES ADDED ON D4034-3 RIB	SC	10.12.20
A	NEW ISSUE	AJS	10.03.04
REV.	DESCRIPTION	BY	DATE
DESIGN	AJS	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
DRAWN	SC		
CHECKED	R	DRAWING NO.	REV. B
MFG. APPR.	M	D4034	SHEET 1 OF 4
APPROVED	M	TITLE	SCALE
DE APPR.	M	UPPER RIB ASSY, BASKET BASE	NTS
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W/O:		WORK ORDER CHANGES						
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector	

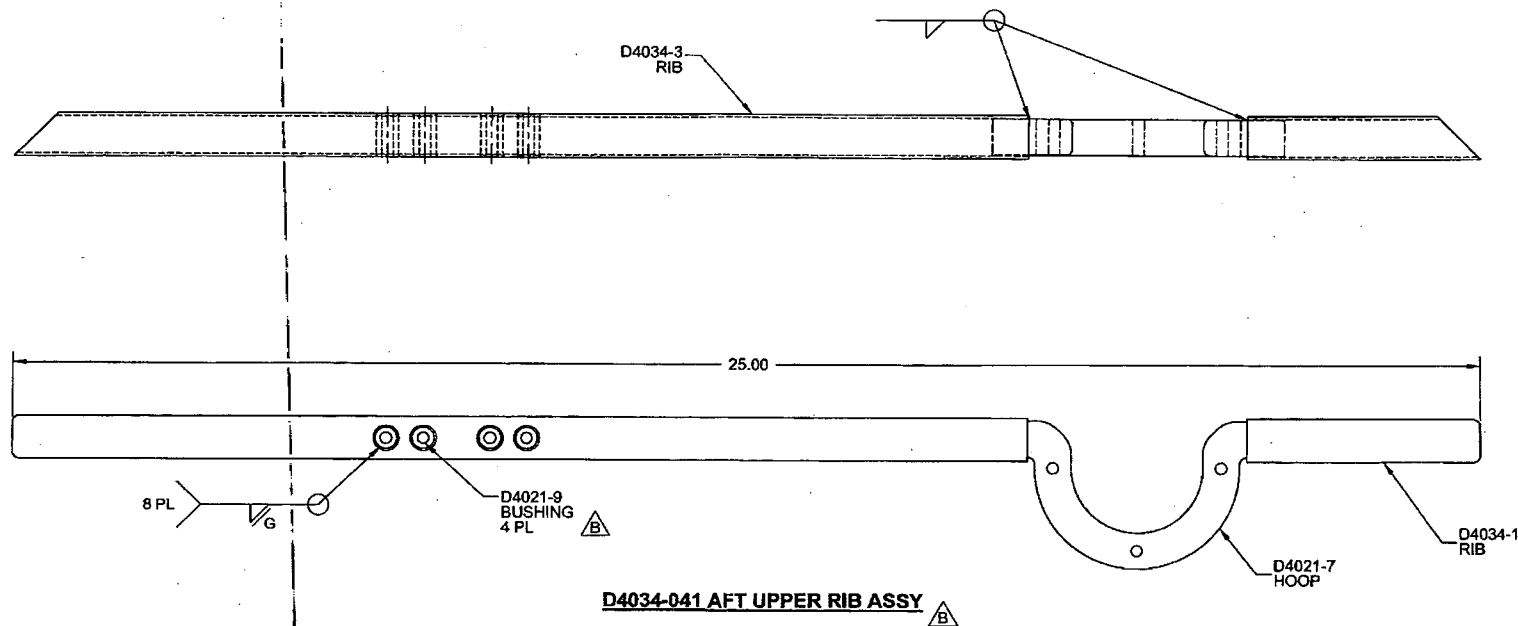
Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

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			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

78328



RELEASED
R 2011-01-38 D

NOTES:

- 1) MATERIAL: N/A
- 2) FINISH: NONE
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: N/A
- 7) WEIGHT: 1.61 lbs
- 8) WELD PER DART QSI 004

DESIGN	AJS	DART AEROSPACE LTD	
DRAWN	SC	HAWKESBURY, ONTARIO, CANADA	
CHECKED	B	DRAWING NO.	REV. B
MFG. APPR.		D4034	SHEET 2 OF 4
APPROVED		TITLE	SCALE
DE APPR.		UPPER RIB ASSY, BASKET BASE	NTS
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			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

78328

0.94

D2327-3
SPACER BUSHING

25.00

D4034-5
RIB

D4021-7
HOOP

D4034-1
RIB

D4034-043 FWD UPPER RIB ASSY

RELEASED
2011-01-18

NOTES:

- 1) MATERIAL: N/A
- 2) FINISH: NONE
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: N/A
- 7) WEIGHT: 1.58 lbs
- 8) WELD PER DART QSI 004

DESIGN	AJS	DART AEROSPACE LTD	
DRAWN	SC	HAWKESBURY, ONTARIO, CANADA	
CHECKED	IS	DRAWING NO.	REV. B
MFG. APPR.	<i>[Signature]</i>	D4034	SHEET 3 OF 4
APPROVED	<i>[Signature]</i>	TITLE	SCALE
DE APPR.		UPPER RIB ASSY, BASKET BASE	NTS
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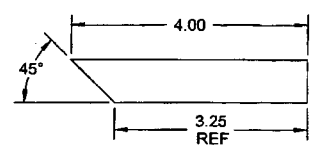
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Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

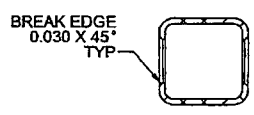
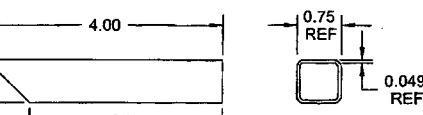
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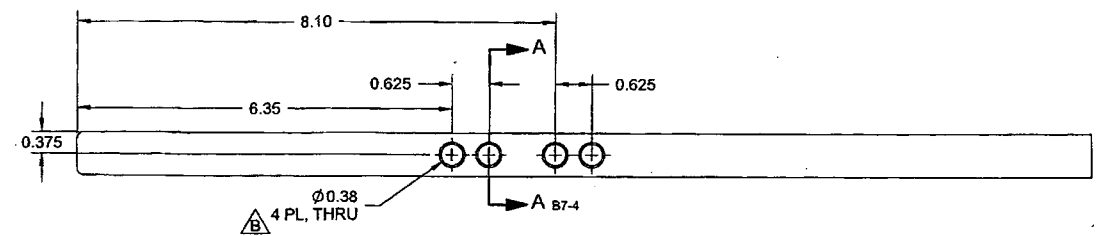
78328



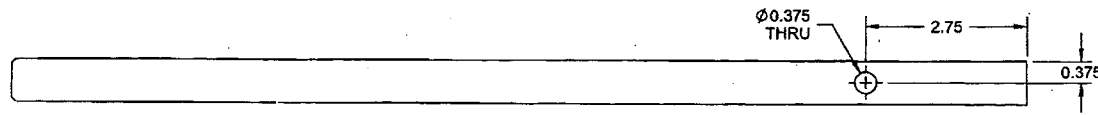
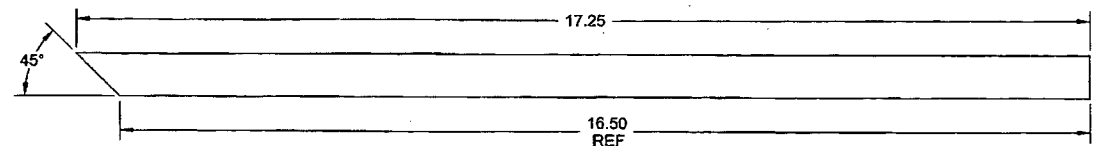
D4034-1 RIB



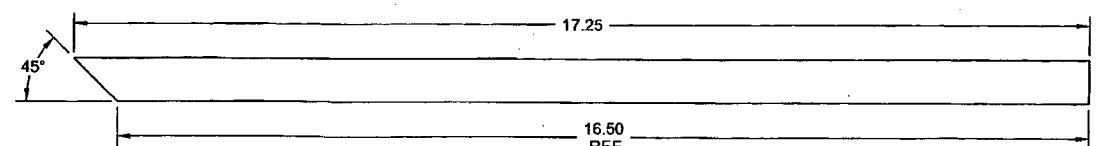
SECTION A-A D4-4






D4034-3 RIB



D4034-5 RIB



- NOTES:**
- 1) MATERIAL: AISI 304/316 STAINLESS STEEL SQUARE TUBE, 0.75 X 0.75 X 0.049 WALL
REF DART SPEC. M304TS0.750W.049
 - 2) FINISH: NONE
 - 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
 - 4) UNITS: INCHES UNLESS OTHERWISE NOTED
 - 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
 - 6) IDENTIFICATION: N/A
 - 7) WEIGHT -1: 0.13 lbs
-3 & -5: 0.62 lbs

DESIGN	AJS	DART AEROSPACE LTD	
DRAWN	SC	HAWKESBURY, ONTARIO, CANADA	
CHECKED	SC	DRAWING NO.	REV. B
MFG. APPR.		D4034	SHEET 4 OF 4
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